

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37604
Estimate Number : 11874

Drawing Name : HOUSING WELDMENT

P.O. Number :
This Issue : 2/26/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : LARGE FAB ASSY
Previous Run : 35075

Part Number : D2207041
Drawing Number : D2207 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 3/22/2008

Qty: 10 U/m: Each

Written By :
Checked & Approved By :
Comment : Est C 01.10.18 Added Step 10 and 11 SM
Est D 07-10-11 REV C dwg DD verified by EC

Additional Product

Job Number:

Seq. #

Machine Or Operation:

Description :

1.0

D2208

End Cap

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description	Batch
2	D2208	End cap	B337743 ✓

2.0

D22071

Housing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description	Batch
1	D2207-1	Housing	B35094 → 8x ✓ B34326 → 2x ✓

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Chamfer D2208 and D2207-1 before welding

2-Weld as per dwg D2207

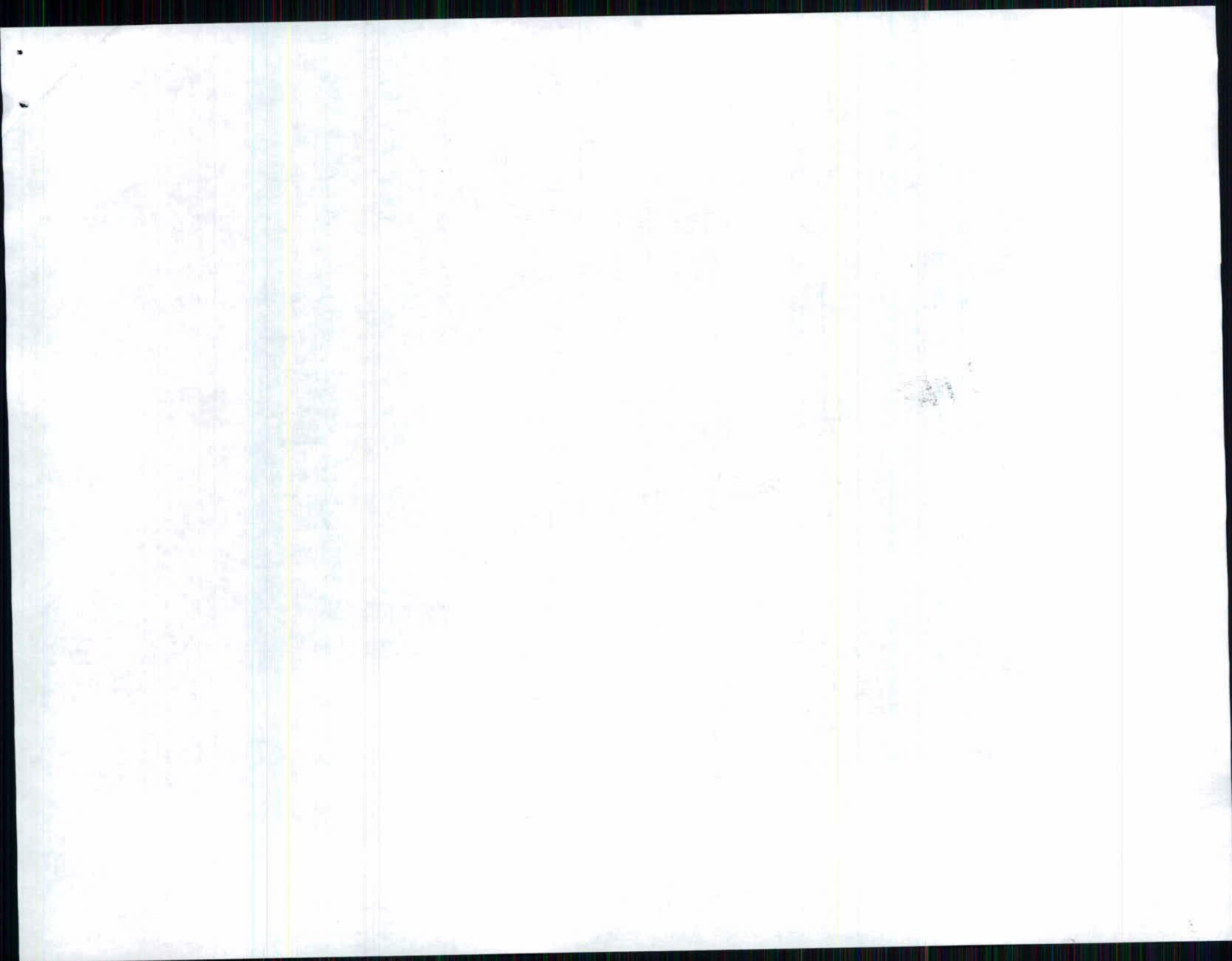
3-Grind welds flush as per Dwg D2207

4.0

QC 10/5

VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION



User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTK

Comment: SMALL FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 08/12/22

7

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/09 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/09

12

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

M 109996
8:00
3:30
5:30

BR 09-02-10

11

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/10

11

10.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Insert

Qty Part Number

Description Batch

4 ALS7-1032-130

Insert

M 108606

SEE QSI 017

FL

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

FL 09/02/10

11

12.0

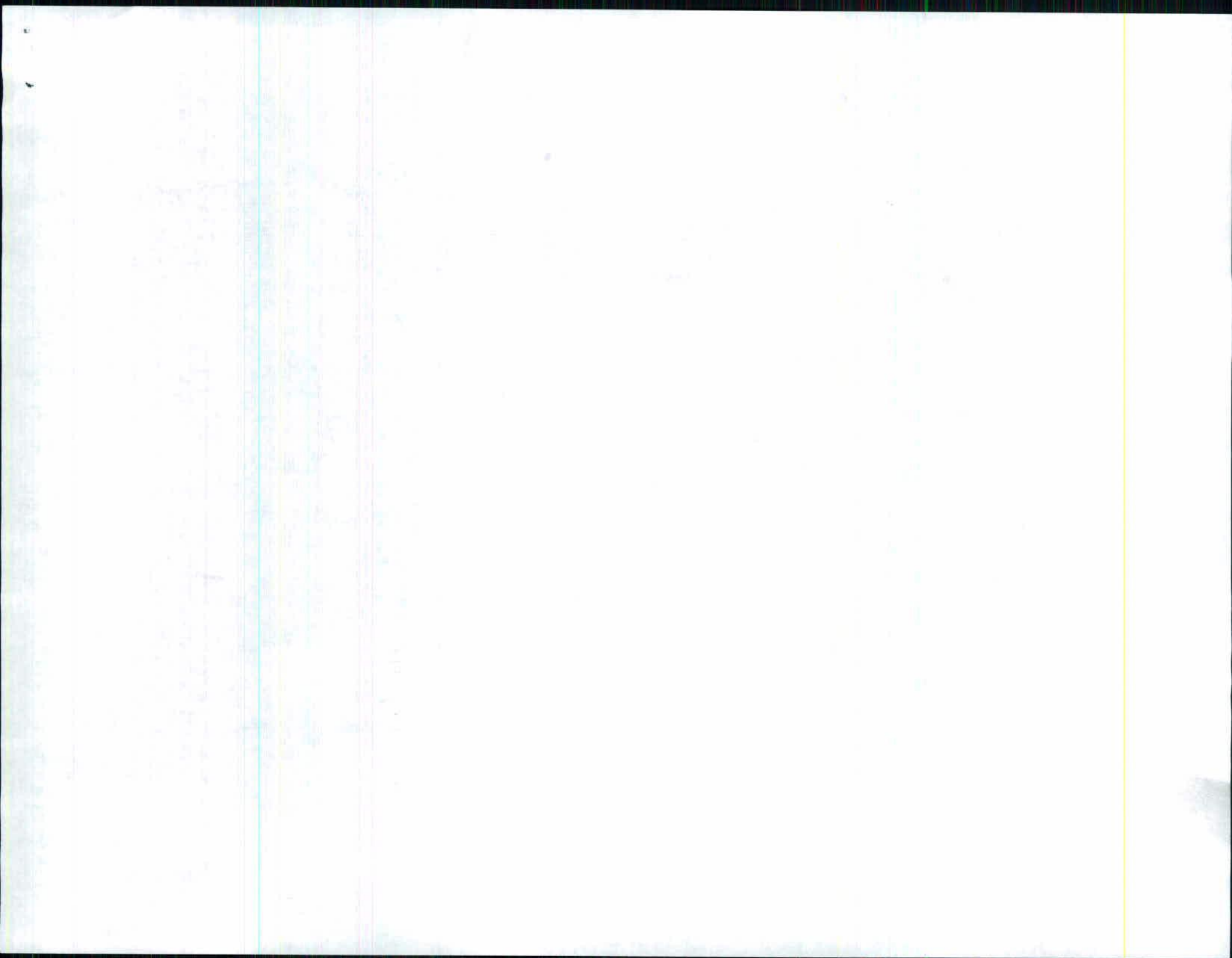
QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



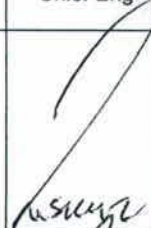



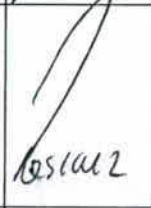

S 09/02/10 (40)



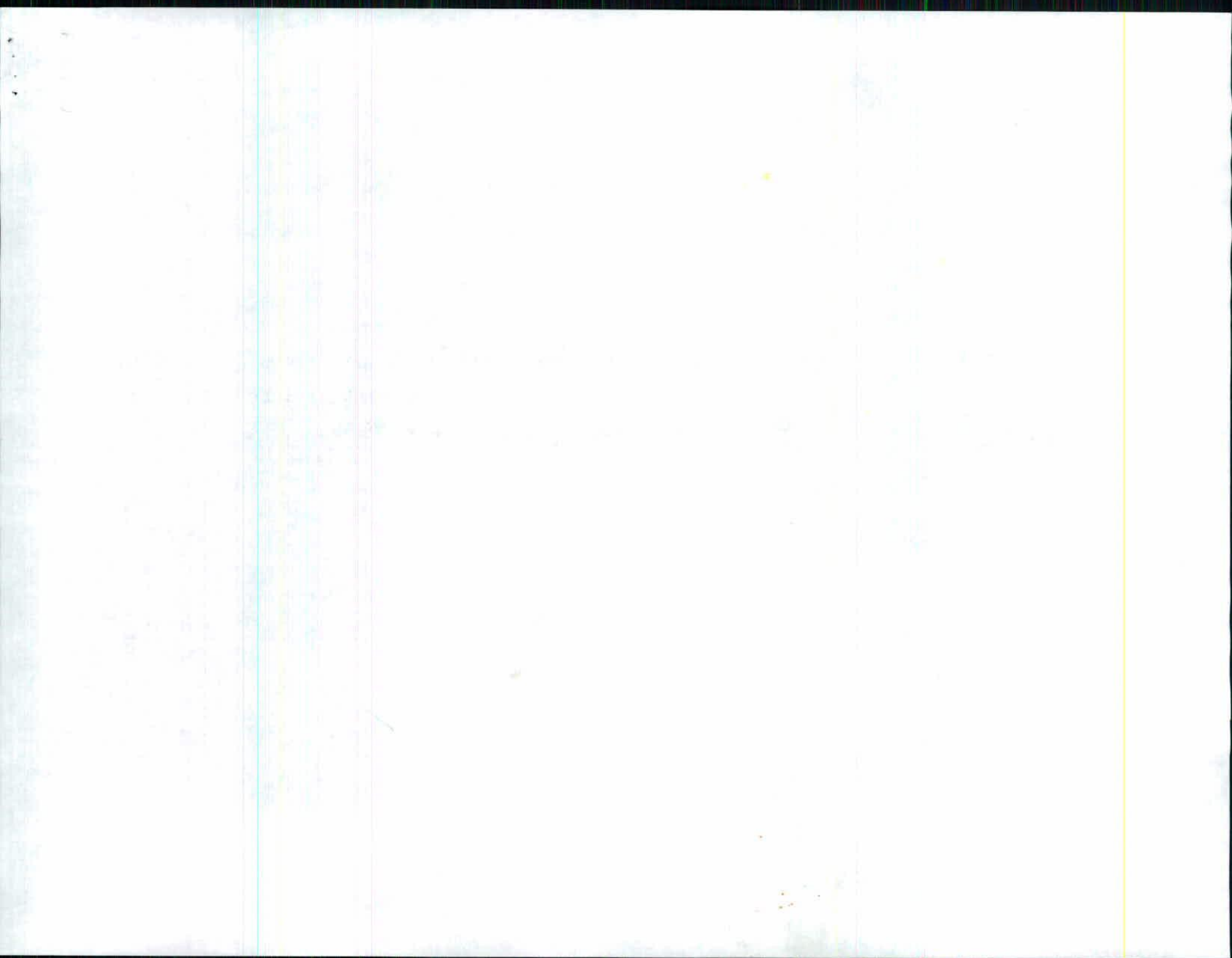
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2207-041 PAR #: N/A Fault Category: Prod / Pre-assy media Small NCR: Yes No DQA: A Date: 08/12/22
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: A Date: 08/12/22

NCR: <u>37604-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/22	5.0	1 Hole out of tolerance Drill got caught and enlarged Hole R.C. Part moved / process.		Scrap + Destroy Not replace Replace	FF 08/12/22			
08-12-23	3.0	reweld holes on part grind flush Holes were not drilled to draw.ing. Were off 0.060" → 0.068" up & across.		reweld holes on part grind flush ready for redrilling	FF 08-12-23			

NOTE: Date & initial all entries



Process Sheet

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Drawing Name: HOUSING WELDMENT

Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 4294

09/02/10

14.0

QC21

FINAL INSPECTION/W/O RELEASE



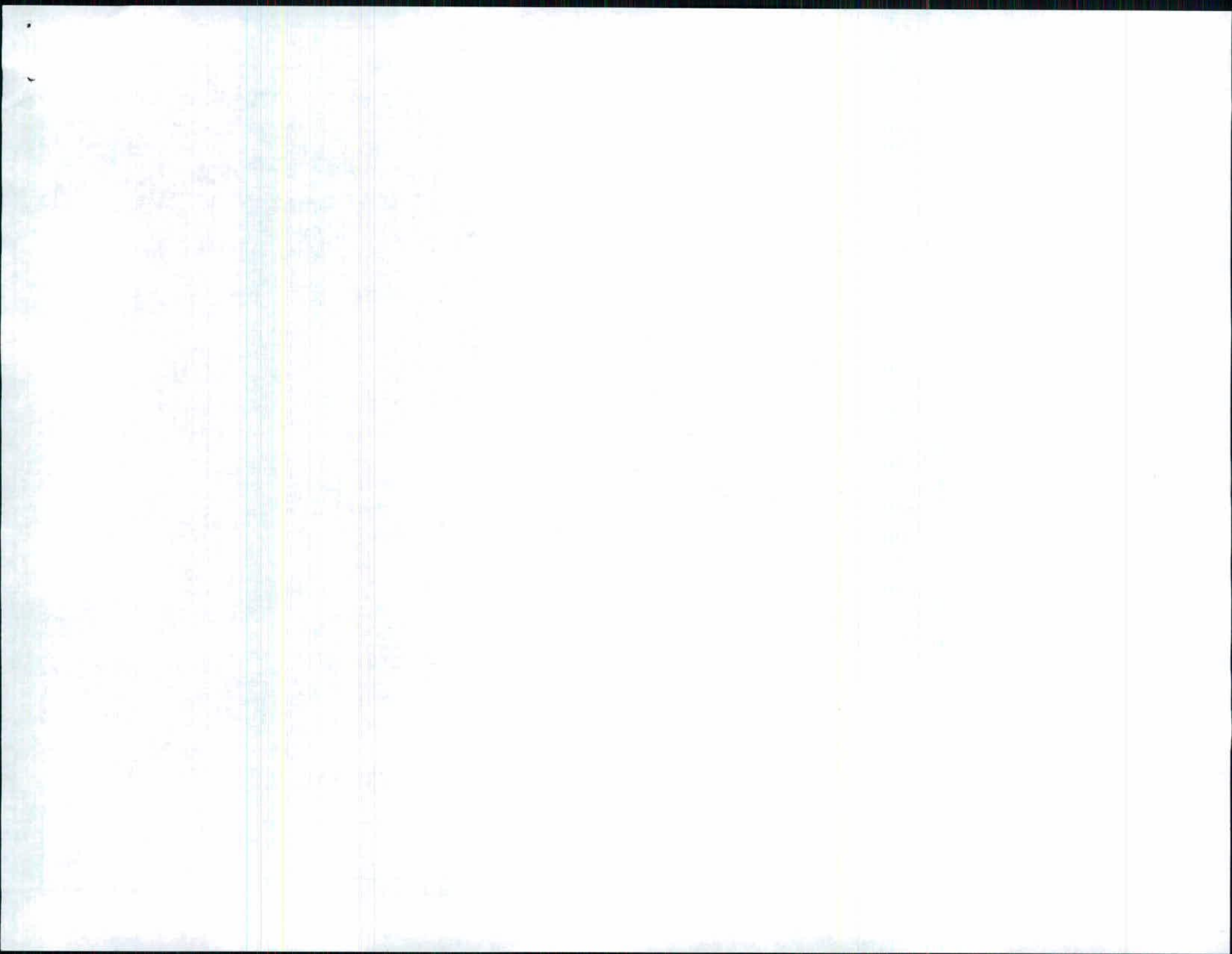
09/02/10

Comment: FINAL INSPECTION/W/O RELEASE

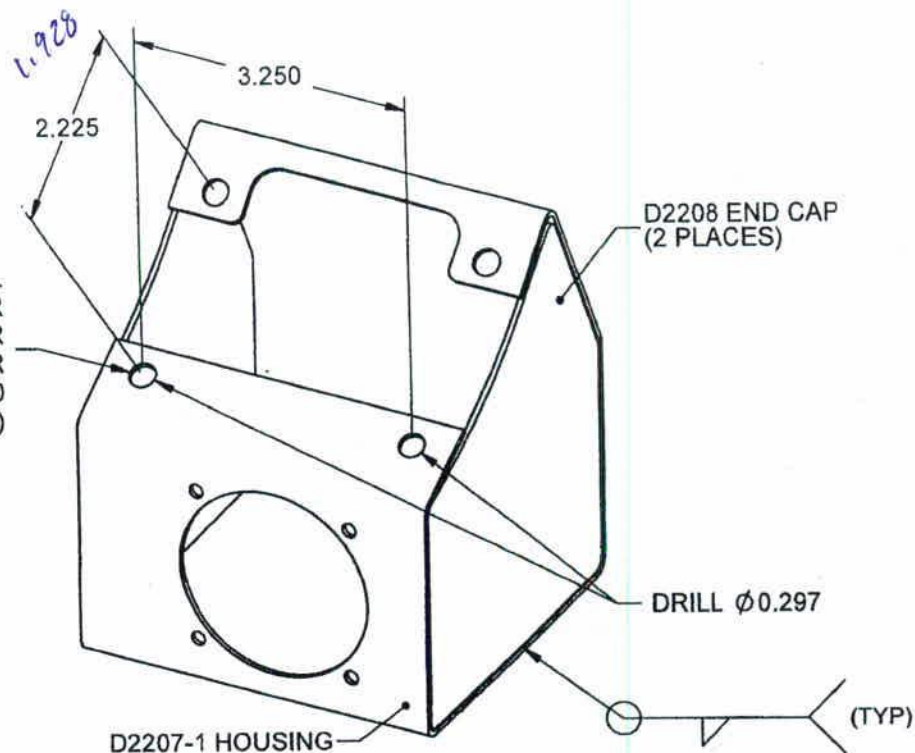
Job Completion



MF 09-02-10



AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



RELEASED

07.08.29

D2207-041 HOUSING ASSEMBLY

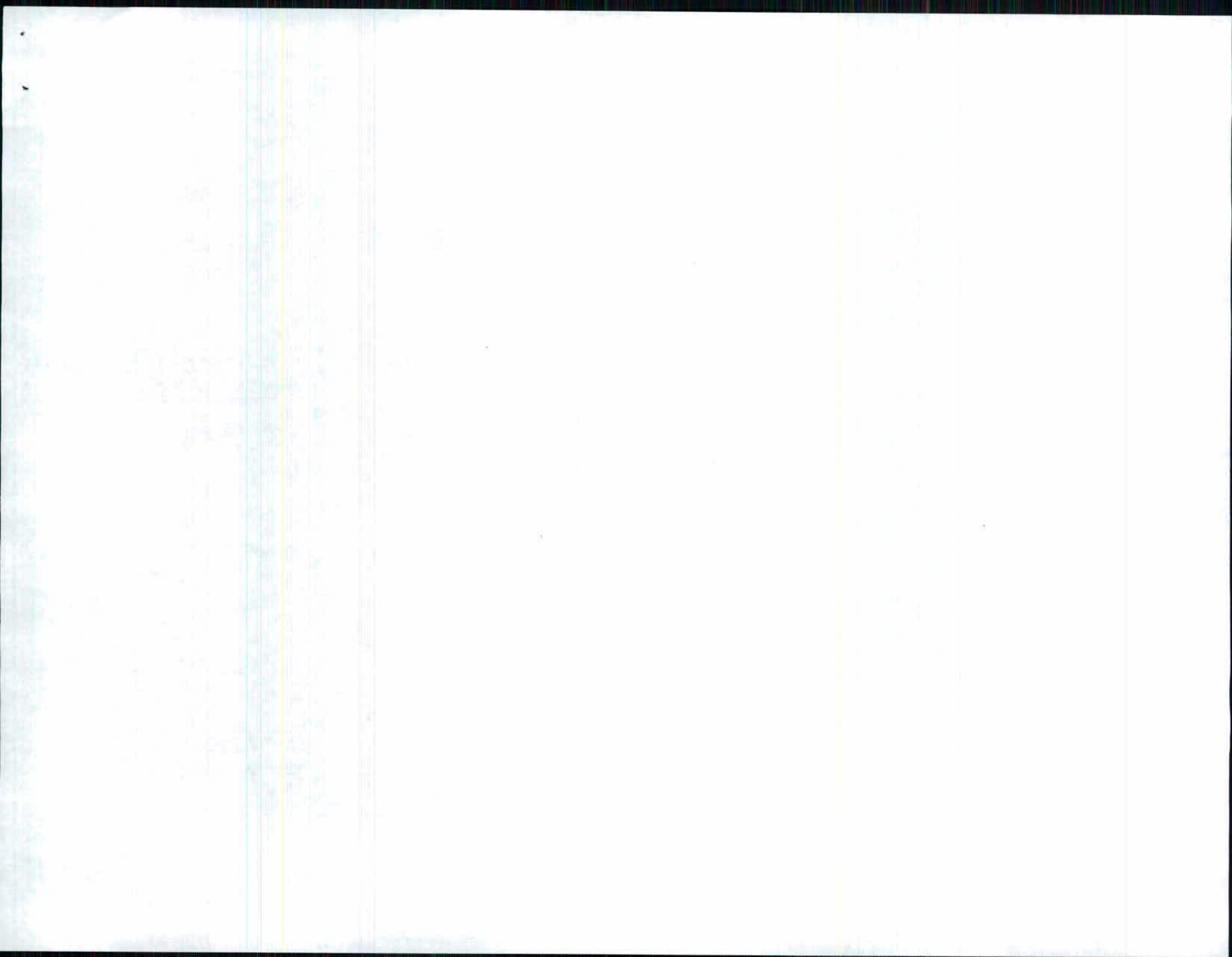
2953

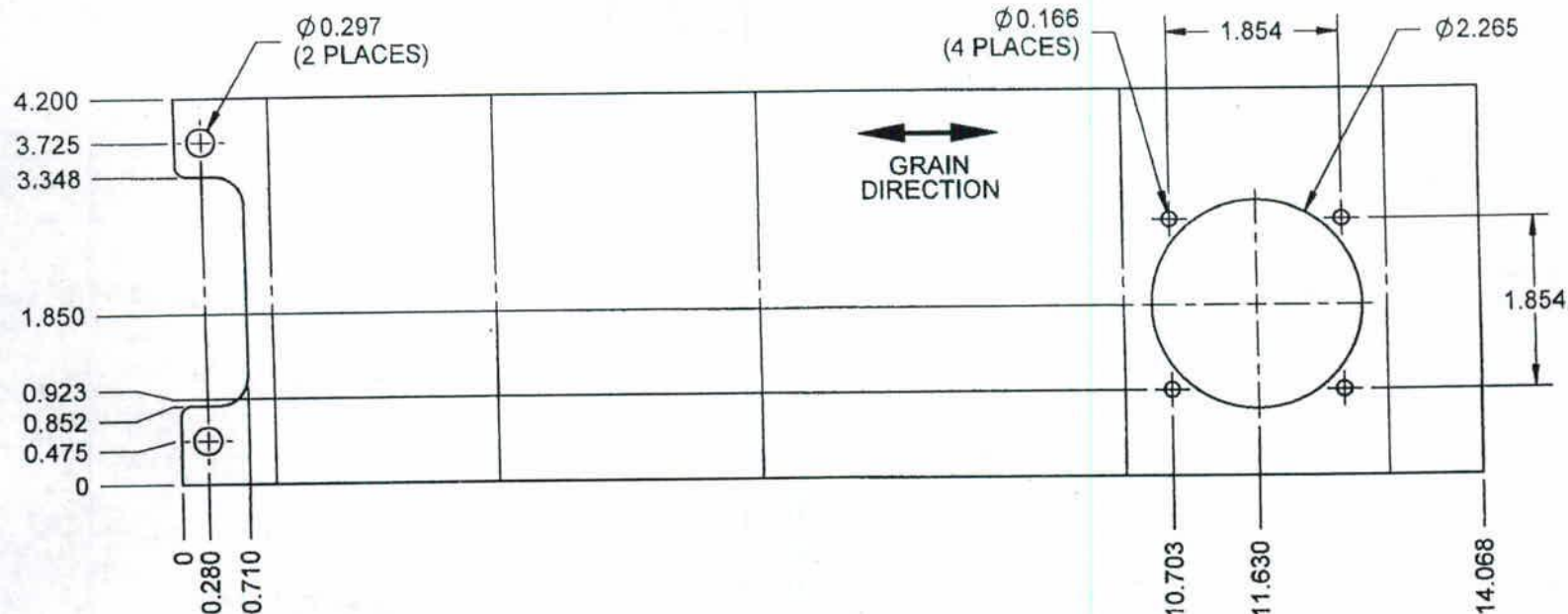
NO. 37604
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2207	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

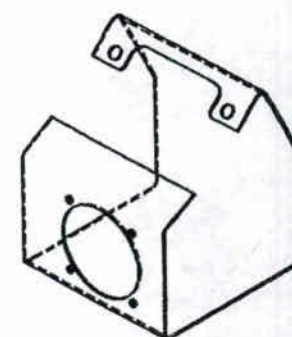




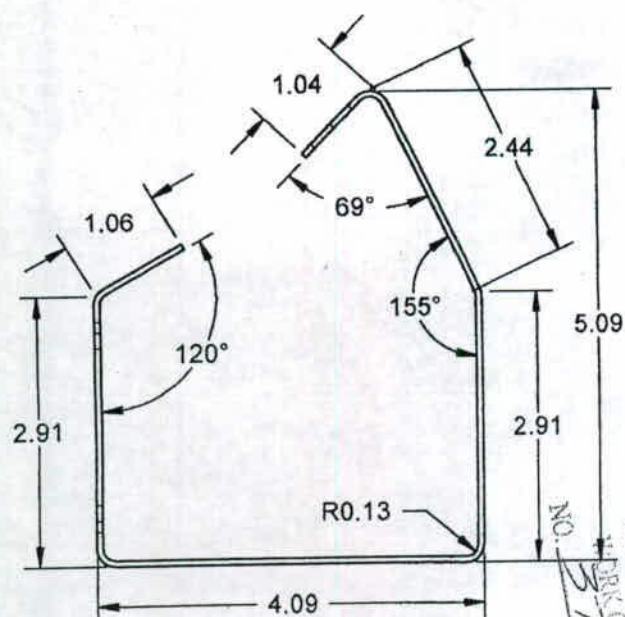
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

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DESIGN	PH	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2207	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
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